

Date: Wednesday, 1/31/2007 2:18:48 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE  
Job Number : 30551  
Estimate Number : 10298  
P.O. Number : N/A Part Number : D25773  
This Issue : 1/31/2007 S.O. No. : N/A Drawing Number : D2577 REV E  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : E  
Previous Run : 29960 Material : N/A  
Due Date : 2/12/2007 Qty: 50 Um: Each  
Written By :  
Checked & Approved By :  
Comment : Est. F 02.09.24 Re-format; Incorporated D2577-101/-13 K  
J/RF  
Est. C 06.07.21 waterjet EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 1 sf(s)/Unit Total : 46 sf(s)  
1010/1025/A21/6aA SHEET 0.063 thick

Batch: M103846(50) M101926 CU

SAD 07/03/07

50

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
1-Cut D2577-101 as per Dwg D2577  
Dwg Rev: E  
Prog Rev: E

2-Deburr if necessary

SAD 07/04/07

50 PTU

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/07

51

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

204-03

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1




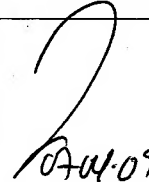

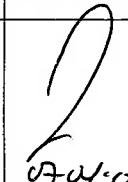

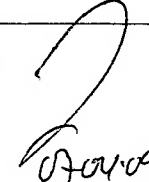


Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

28 mf 07-04-07

49

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/09	2.0	waterjet miss cut a hole 1st part		Scrap and destroy	SAN 07/04/09			
07/04/09	2.0	1 part scrap. hole, was not cut out completely. very bad.		Scrap & destroy	SB 07/04/09			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:18:48 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 30551

Part Number: D25773

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Identify as D2577-3

mf

07-04-09

(49)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/10

(49)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

Batch

A/R 7560 Hardcoat Rod

M103794 M103551

FC 07/04/18

(49)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/18

(49)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

SS

07-04-19

(49)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

07/04/19

(49)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-15

SS

07-04-19

(49)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

LP 07/04/20

(49)

Job Completion



U JF-M-W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



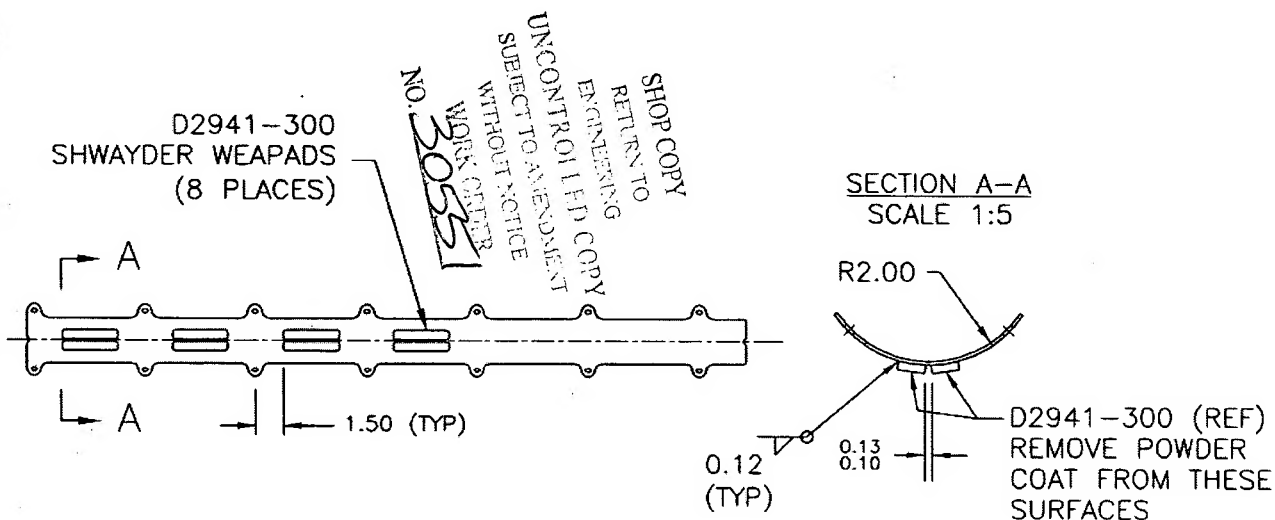
RELEASED  
00 09 22

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED	DRAWING NO. D2577	SHEET 1 OF 5
DATE 00.09.22	TITLE WEARSHOE	SCALE 1:10	
A	96.09.16	NEW ISSUE	
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO OBROUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	



7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308

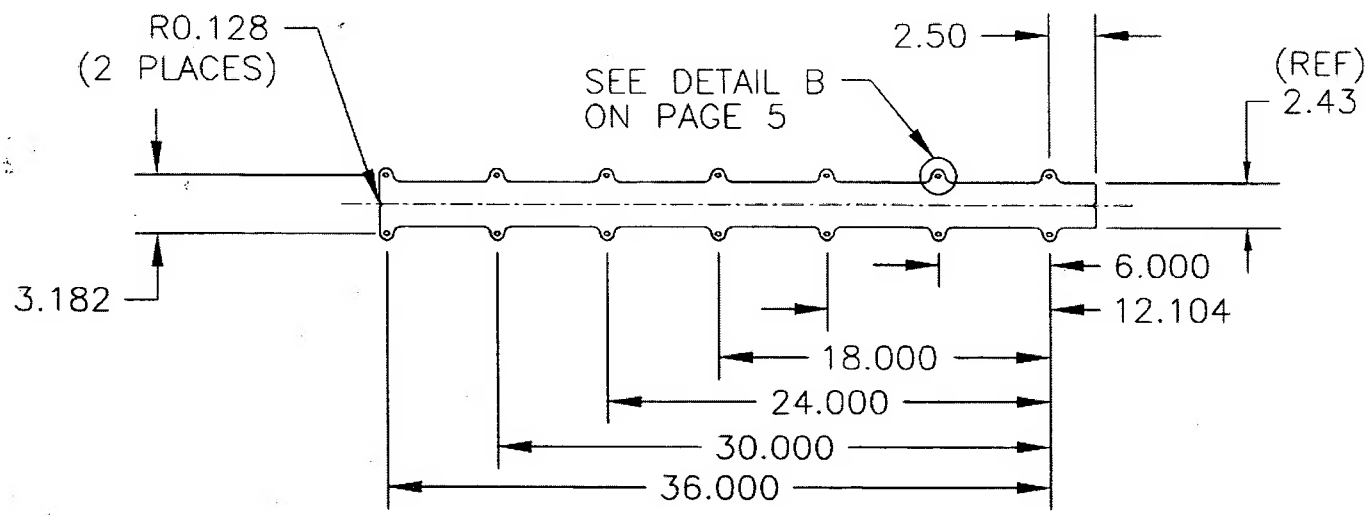
D2577-1 & D2577-3 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-21 & D2577-23 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	✓	DRAWN BY	CP	DART AEROSPACE LTD HAMESBURY, ONTARIO, CANADA
CHECKED	✓	APPROVED	✓	DRAWING NO. D2577
DATE 00.09.22				TITLE WEARSHOE
				REV. E SHEET 2 OF 5 SCALE 1:10

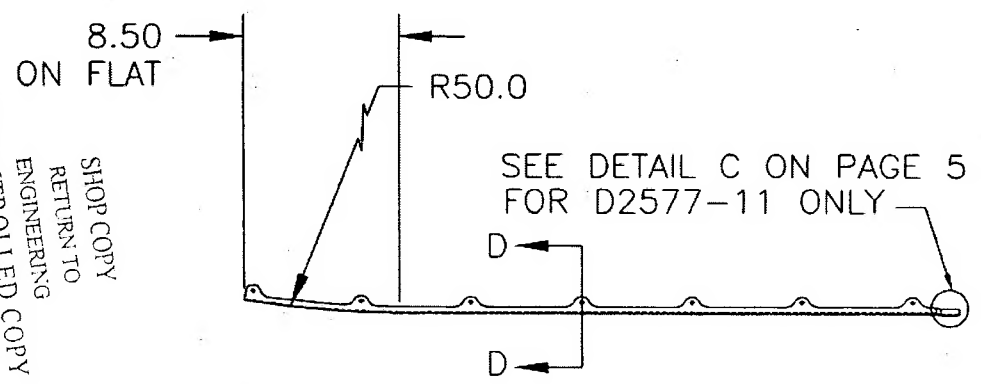


**D2577-101 FLAT PATTERN**

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**D2577-11 & D2577-13 LONGITUDINAL BEND**

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
00.09.26 #

NO. 30551  
WORK ORDER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
SHOP COPY  
RETURN TO  
ENGINEERING  
NO. 30551

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

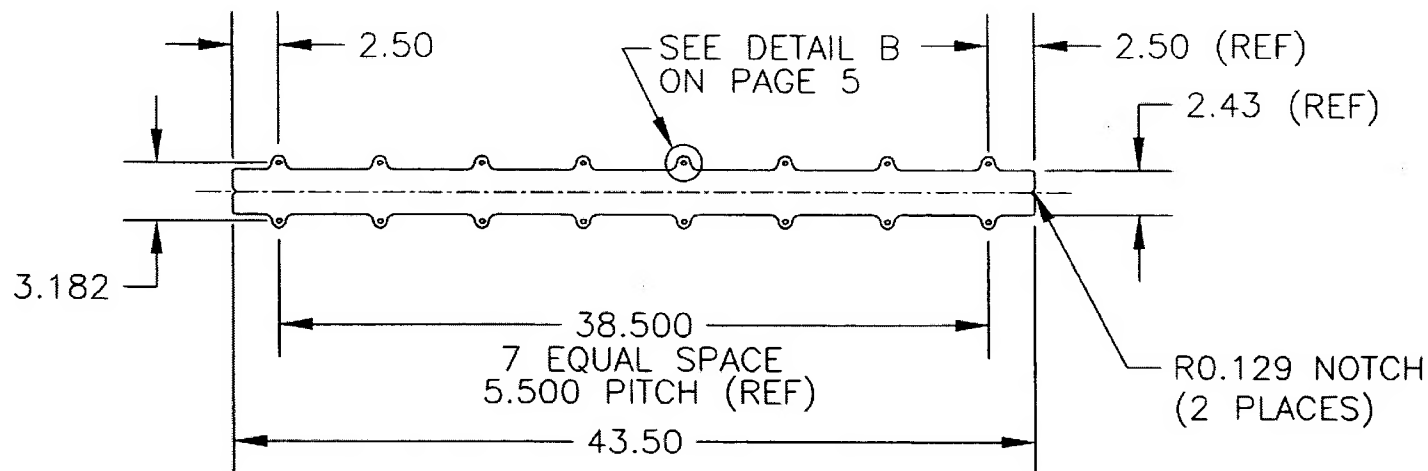
Copyright © 1996 by DART AEROSPACE LTD



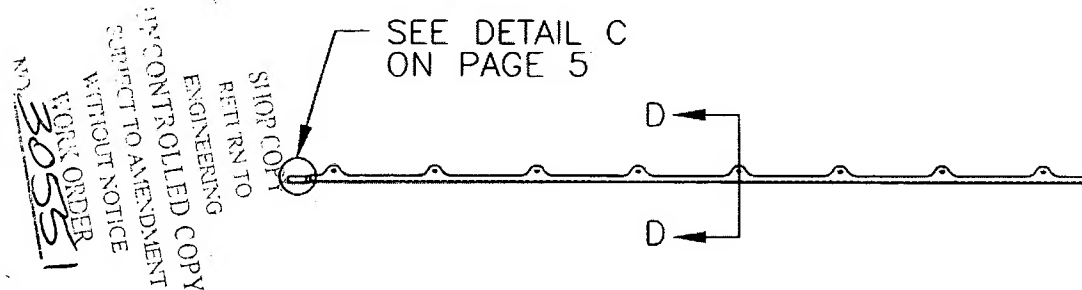
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2577	SHEET 3 OF 5
DATE 00.09.22	TITLE WEARSHOE	SCALE 1:10	

RELEASED  
00.09.26

### D2577-5 FLAT PATTERN



### D2577-5 LONGITUDINAL BEND



### D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

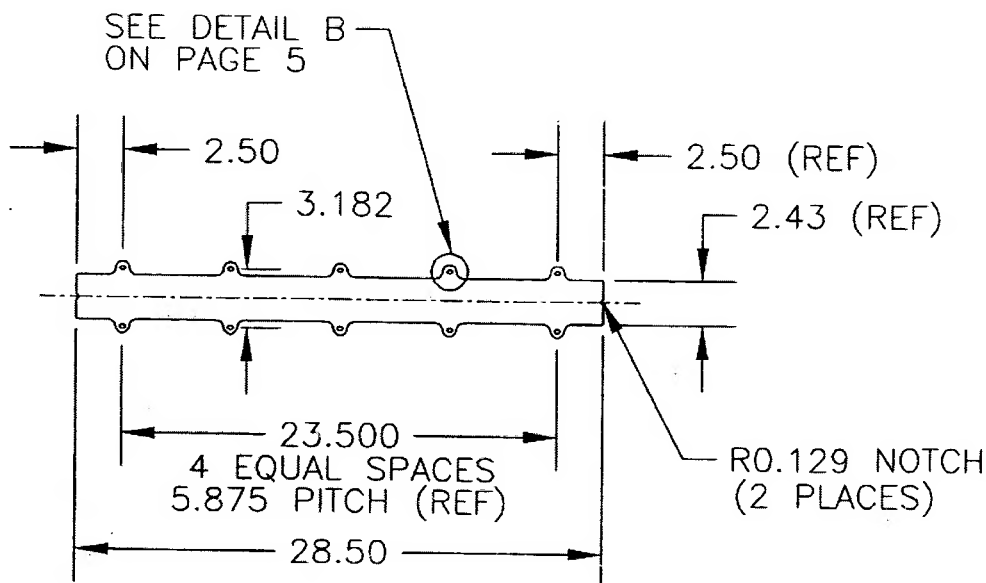
**DART**



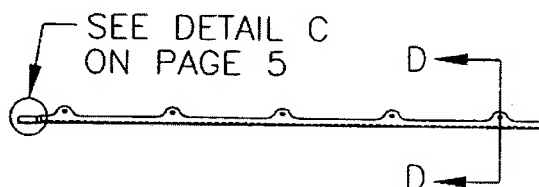
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	
DATE		D2577	SHEET 4 OF 5	
00.09.22		TITLE	SCALE	
		WEARSHOE	1:10	

**RELEASED**  
00 09 26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30551

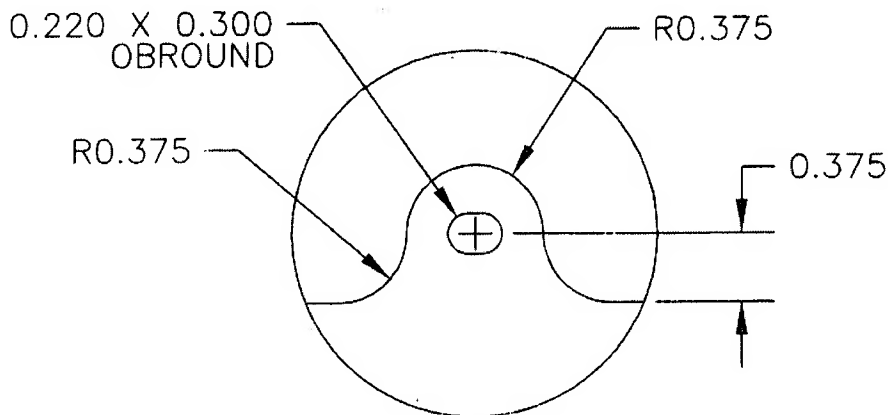




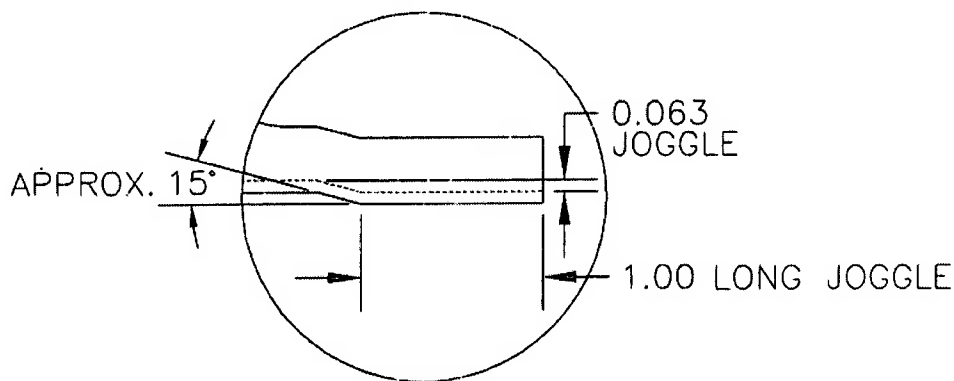
DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

DETAIL B (SCALE 1:1)

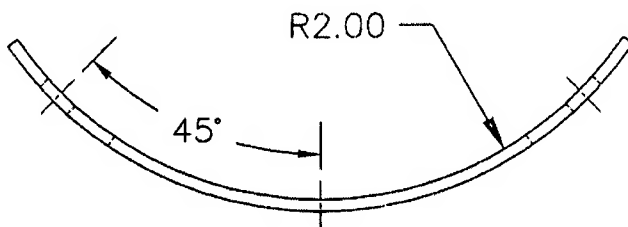
RELEASED  
00.09.26



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30557

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 30551
<b>Description:</b>		<b>Part Number:</b> D25773
<b>Inspection Dwg:</b>	<b>Rev:</b>	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	3.182	+/- 0.010	3.186	✓		Vern	
B	36.000	+/- 0.010	36.000	✓		M-T	
C	30.000	+/- 0.010	30.000	✓		M-T	
D	24.000	+/- 0.010	25.000	✓		M-T	
E	18.000	+/- 0.010	18.000	✓		M-T	
F	12.104	+/- 0.010	12.109	✓		Vern	
G	6.000	+/- 0.010	6.001	✓		Vern	
H	2.43	+/- 0.030	2.44	✓		Vern	
I	2.50	+/- 0.030	2.50	✓		Vertical Vern	
J	0.220	+/- 0.010	0.217	✓		Vern	
K	0.300	+/- 0.010	0.300	✓		Vern	
L	0.063	+/- 0.010	0.060	✓		Vern	
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

<b>Measured by:</b> SAN	<b>Audited by:</b> Sn	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/04/07	<b>Date:</b> 07/04/07	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	